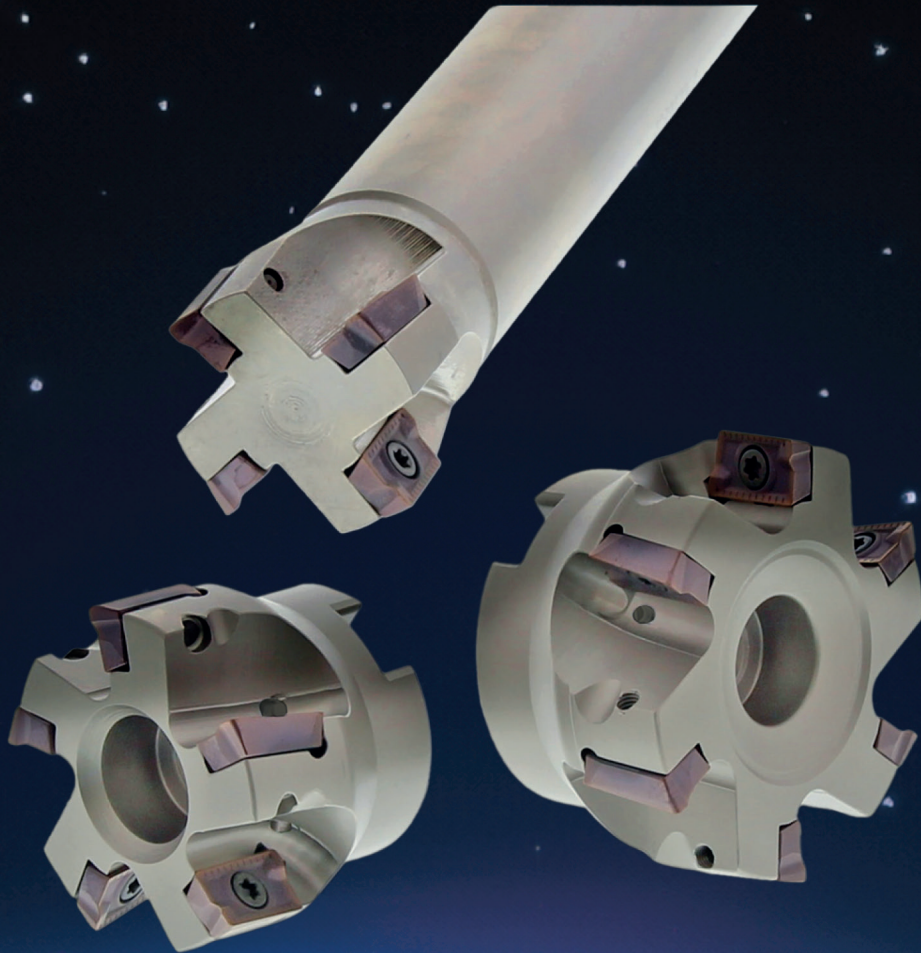




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2023



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MILLING

THREADING

MILLING

THREAD MILLING

TURNING

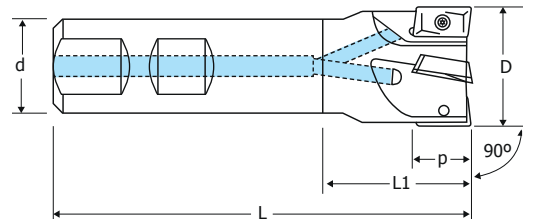
DRILLING

GROOVING & PARTING

Ordering Code	Specifications	Page
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Shoulder Milling

CAP 9011W



ART.	D	d	L	L1	p	Z
CAP 9011W-D10	10	16	80	24	11	1
CAP 9011W-D12	12	16	80	24	11	1
CAP 9011W-D14	14	16	80	24	11	1
CAP 9011W-D16	16	16	85	25	11	2
CAP 9011W-D18	18	20	85	25	11	2
CAP 9011W-D20	20	20	90	25	11	3
CAP 9011W-D22	22	25	95	25	11	3
CAP 9011W-D25	25	25	95	25	11	4
CAP 9011W-D28	28	25	95	25	11	4
CAP 9011W-D30	30	25	95	25	11	4
CAP 9011W-D32	32	25	95	26	11	5

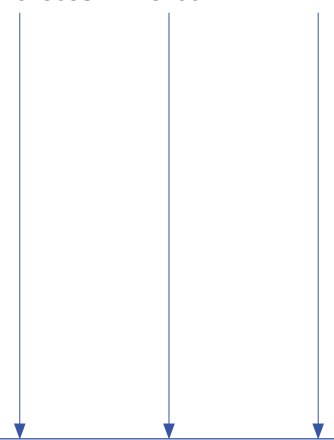


Insert

FTKA 02565S

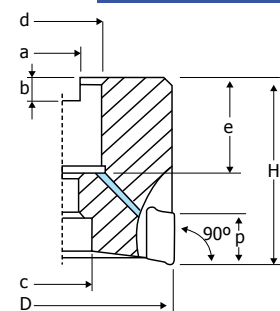
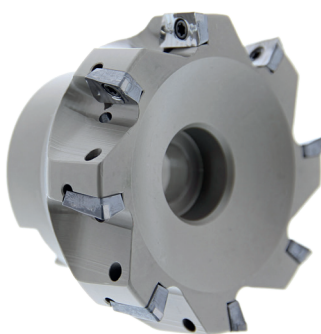
CT08

APKT 11T3



Shoulder Milling

CAP 9011B



ART.	D	d	c	e	a	b	H	p	Z
CAP 9011B-D40	40	22	17	21	10,4	6,3	40	11	6
CAP 9011B-D50	50	22	17	21	10,4	6,3	40	11	7
CAP 9011B D63	63	22	17	21	10,4	6,3	40	11	8



Insert

FTKA 02565S

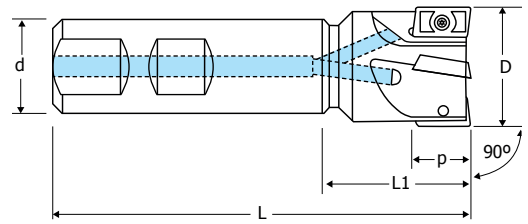
CT08

APKT 11T3



Shoulder Milling

CAP 9016W



ART.	D	d	L	L1	p	Z
CAP 9016W-D25	25	25	100	44	16	2
CAP 9016W-D32	32	32	110	50	16	3
CAP 9016W-D40	40	32	115	45	16	4



VT40



CT15

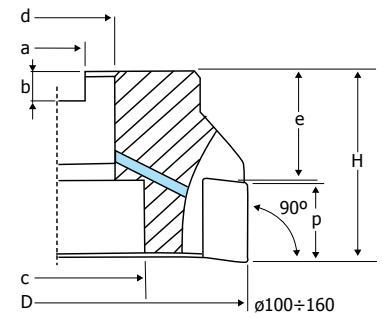
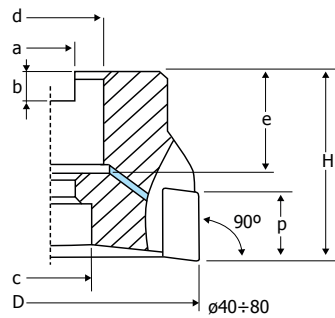
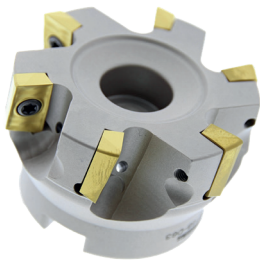
Insert

APKT 1604



Shoulder Milling

CAP 9016B



ART.	D	d	c	e	a	b	H	p	Z
CAP 9016B-D40	40	16	12	18	8,4	5,6	40	16	4
CAP 9016B-D50	50	22	18	21	10,4	6,3	40	16	5
CAP 9016B-D63	63	22	18	21	10,4	6,3	40	16	6
CAP 9016B-D80	80	27	20	22	12,4	7	50	16	7
CAP 9016B-D100	100	32	45	26	14,4	8	50	16	8
CAP 9016B-D125	125	40	56	38	16,4	9	63	16	9
CAP 9016B-D160	160	40	87	32	16,4	9	63	16	10



VT40



CT15

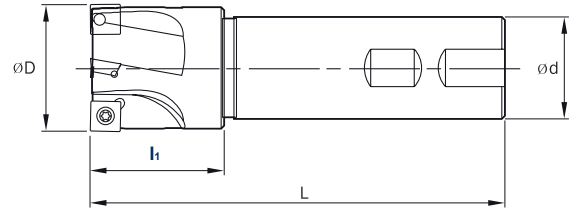
Insert

APKT 1604



Shoulder Milling

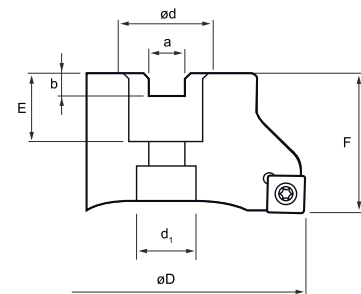
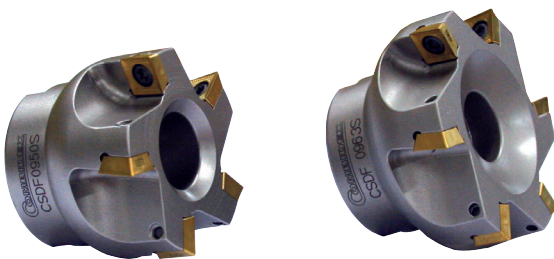
CSDF 09..SW



ART.	øD	ød	l1	L	Z	Price	Insert
CSDF 0925 SW	25	25	35	115	2	€ 115	SDXT
CSDF 0932 SW	32	25	40	125	3	€ 202	↓
CSDF 0940 SW	40	32	40	130	4	€ 230	

Shoulder Milling

CSDF 09.. S



ART.	øD	ød	d1	a	b	E	F	Z	Price	Insert
CSDF 0950 S	50	22	18	10,4	6,3	20	40	5	€ 243	SDXT
CSDF 0963 S	63	22	18	10,4	6,3	20	40	6	€ 272	↓

ACTIE

Freesbody	Wisselplaatjes	Prijs
CSDF 0925 SW	+10 SDXT 09 M405R	€ 90
CSDF 0925 SW	+20 SDXT 09 M405R	€ 118
CSDF 0925 SW	+30 SDXT 09 M405R	€ 145
CSDF 0925 SW	+50 SDXT 09 M405R	€ 171
CSDF 0932 SW	+10 SDXT 09 M405R	€ 98
CSDF 0932 SW	+20 SDXT 09 M405R	€ 126
CSDF 0932 SW	+30 SDXT 09 M405R	€ 156
CSDF 0932 SW	+50 SDXT 09 M405R	€ 185
CSDF 0940 SW	+10 SDXT 09 M405R	€ 105
CSDF 0940 SW	+20 SDXT 09 M405R	€ 136

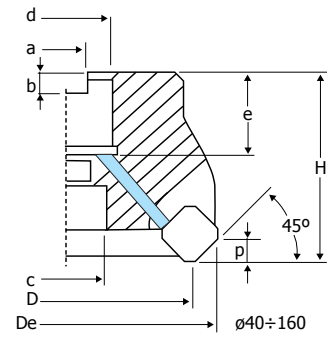
Freesbody	Wisselplaatjes	Prijs
CSDF 0940 SW	+30 SDXT 09 M405R	€ 168
CSDF 0940 SW	+50 SDXT 09 M405R	€ 200
CSDF 0950 S	+10 SDXT 09 M405R	€ 112
CSDF 0950 S	+20 SDXT 09 M405R	€ 146
CSDF 0950 S	+30 SDXT 09 M405R	€ 180
CSDF 0950 S	+50 SDXT 09 M405R	€ 214
CSDF 0963 S	+10 SDXT 09 M405R	€ 120
CSDF 0963 S	+20 SDXT 09 M405R	€ 156
CSDF 0963 S	+30 SDXT 09 M405R	€ 192
CSDF 0963 S	+50 SDXT 09 M405R	€ 228



Aanbevolen richtwaarden voor snijnelheid en voeding van de CSDF

Wisselplaat SDXT 09 M4 voor staal MF en MM, voor aluminium MAP

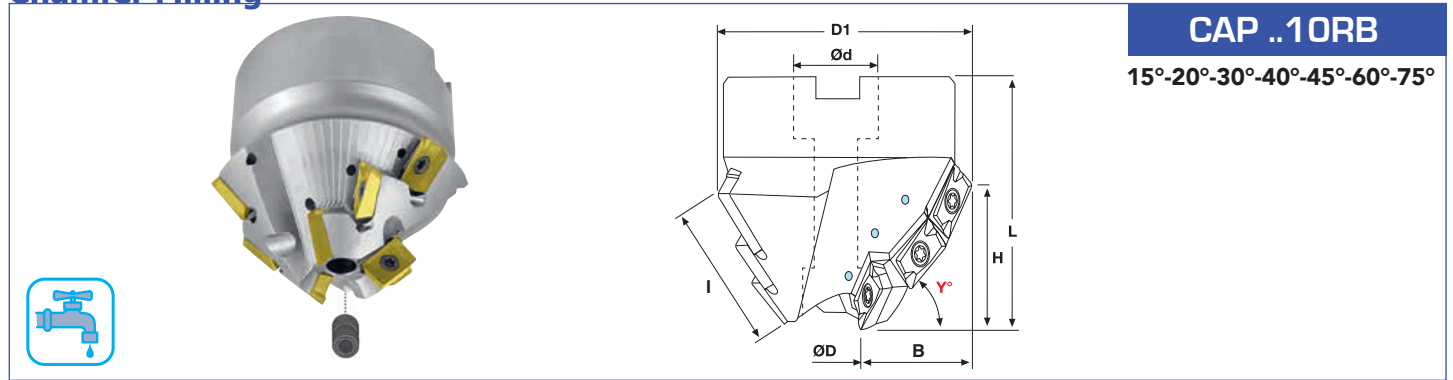
Materiaal	Snijnelheid	Type MF fz (mm/tand)	Type MM fz (mm/tand)
Staal PC30M	100 - 250 m/min	0.05 - 0.2	0.1 - 0.3
Materiaal	Snijnelheid	Type MAP fz (mm/tand)	
Aluminium K10M	400 - 1000 m/min	0.05 - 0.4	

CSE 4512B



ART.	D	De	d	c	e	a	b	H	p	Z			Insert
CSE 4512B-D40	40	53	16	14	18	8,4	5,6	40	6	3	VT5011	CT20	SEHW
CSE 4512B-D50	50	63	22	17	21	10,4	6,3	48	6	4	↓	↓	SEHT
CSE 4512B-D63	63	76	22	19	21	10,4	6,3	48	6	5	↓	↓	1204
CSE 4512B-D80	80	93	27	38	24	12,4	7	50	6	6	↓	↓	↓
CSE 4512B-D100	100	113	32	45	26	14,4	8	50	6	6	↓	↓	↓
CSE 4512B-D125	125	138	40	56	32	16,4	9	63	6	7	↓	↓	↓
CSE 4512B-D160	160	173	40	-	-	-	9	63	6	8	↓	↓	↓

Chamfer Milling

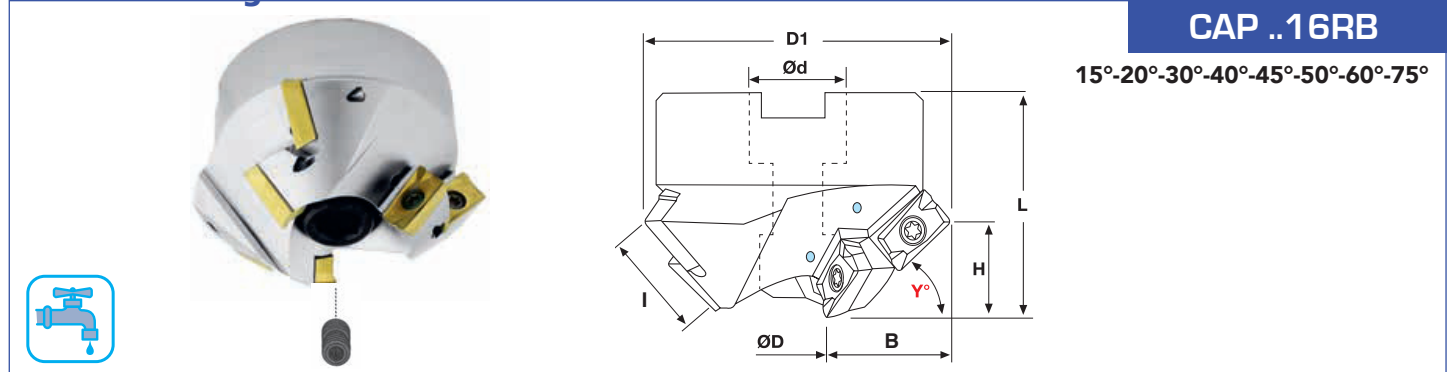


CAP ..10RB

15°-20°-30°-40°-45°-60°-75°

ART.	ØD	D1	Ød	L	B	I	Y°	H	Z	K	FTKA 02565S	CT08	Insert
CAP 4510 RB	17	56	22	50	17,8	27,5	45°	19	9	3	FTKA 02565S	CT08	APXT
CAP 6010 RB	17	45	16	50	13	27,5	60°	24	9	3			APKT
CAP 3010	17	65	22	50	24	27,5	30°	13	9	3			1003
CAP 1510	17	70	22	50	27	27,5	15°	7	9	3			
CAP 7510	19	33	16	60	7	27,5	75°	27	9	3			
CAP 4010	17	60	22	50	19	27,5	40°	17	9	3			
CAP 2010	17	69	22	50	26	27,5	20°	9	9	3			

Chamfer Milling



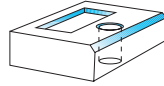
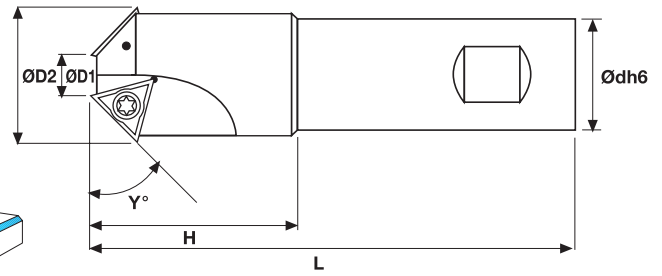
CAP ..16RB



15°-20°-30°-40°-45°-50°-60°-75°

ART.	ØD	D1	Ød	L	B	I	Y°	H	Z	K	VT40	CT15	Insert
CAP 4516RB	35	77,8	27	50	21,4	30	45°	21,5	6	3	VT40	CT15	APXT
CAP 6016RB	35	65	27	50	15,1	30	60°	26,5	6	3			APKT
CAP 3016RB	35	88	27	50	26,5	30	30°	15,0	6	3			1604
CAP 1516RB	35	94	27	50	29,5	30	15°	8,0	6	3			
CAP 7516RB	35	50,7	22	60	8	30	75°	29,5	6	3			
CAP 4016RB	35	84	27	50	24,5	30	40°	19	6	3			
CAP 2016RB	35	91	27	50	28,5	30	20°	10	6	3			
CAP 5016RB	35	73	27	50	18	30	50°	23	6	3			

CTC

Milling cut for chamfering 30°, 45° e 60°



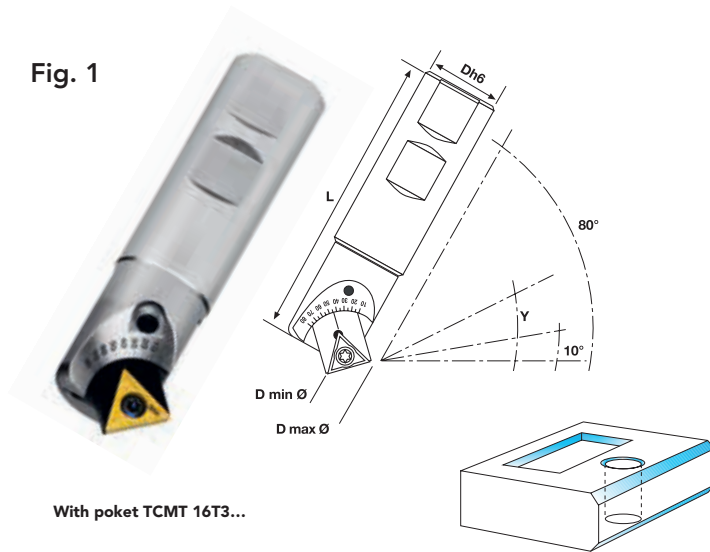
ART.	ØD1	ØD2	L	H	Ødh6	Y°	Z			Insert
CTC 4511W-16	1,2	16	70	20	12	45°	1	FTKA 02565S	CT08	TCMT1102...
CTC 4511W-21	6,2	21	90	35	20	45°	2	FTKA 02565S	CT08	TCMT1102...
CTC 4516W-32	10,4	32,5	100	42	25	45°	2	VT40	CT15	TCMT16T3...
CTC 6011W-16	5,4	16	70	20	12	60°	1	FTKA 02565S	CT08	TCMT1102...
CTC 6011W-27	15,8	26	90	35	20	60°	2	FTKA 02565S	CT08	TCMT1102...
CTC 6016W-32	20	35	100	39	25	60°	2	VT40	CT15	TCMT16T3...
CTC 3016W-32	6	32	100	38	25	30°	2	VT40	CT15	TCMT16T3...

Chamfer Milling

Milling cutters for chamfering-flaring 10° to 80°

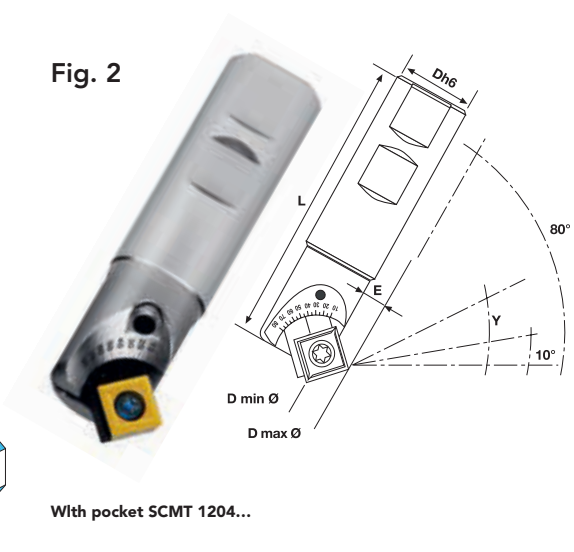
CTC1080

Fig. 1



With poket TCMT 16T3...

Fig. 2



With pocket SCMT 1204...



IN THE MILLING CUTTERS ARE ALWAYS INCLUDED 2 POCKETS T16 NEW + S12 NEW

ART.	Dh6	L	Y°	Fig. 1		Fig. 2		
				D. min. Ø	D. max. Ø	D. min. Ø	D. max. Ø	E
CTC1080-16WD20	20	95	"	"	"	"	"	"
			10°	5	32	7,5	30	2,7
			20°	6	33	10	32	3,6
			30°	7	34	13	32,5	4,3
			40°	10	33	16,5	33,5	4,5
CTC1080-16WD25	25	95	45°	11	33	17,5	33,5	4,6
			50°	13	32	19	33,5	4,6
			60°	16	31	22	33,5	4,3
			70°	19	29	24,5	33,5	3,8
			80°	23	27	27	31	3
CTC1080-16WD25L	25	145	"	"	"	"	"	
CTC1080-16WD25XL	25	195	"	"	"	"	"	

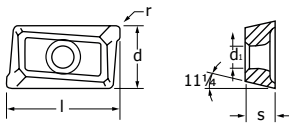
Fig. 1 With pocket TCMT 16T3...

Pocket	Insert	Insert screw	Pocket screw	Key
T16NEW	TCMT16T3...	VT40	M6-16	CT15V

Fig. 2 With pocket SCMT 1204...

Pocket	Insert	Insert screw	Pocket screw	Key
S12NEW	SCMT1204...	VT40S	M6-16	CT20V

APKT 11T3

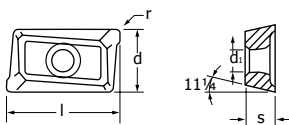


d	l	s	d ₁	r
6,6	12	3,6	2,85	0,5



ART.	K10M	PC30M	PC40M	PA30M	PA40M
APKT 11T3 PDR-WF		•	•		•
APKT 11T3 PDR-VW		•		•	
APKT 11T3 PDR-P	•				

APKT 1604

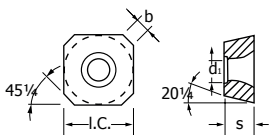


d	l	s	d ₁	r
9,5	17,1	5,3	4,4	0,8

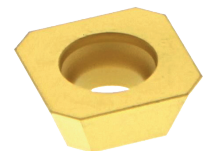


ART.	K10M	PC30M	PC40M	PA30M	PA40M
APKT 1604 PDSR		•			
APKT 1604 PDR-WF		•	•		•
APKT 1604 PDR-VW		•		•	
APKT 1604 PDR-P	•				
APKT 1604 PDR-WP	•				

SEHW 1204

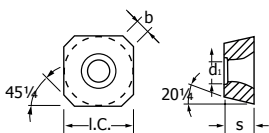


I.C.	s	d ₁	b
12,7	4,76	5,5	2,1

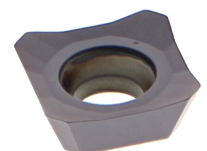


ART.	K10M	PC30M	PC40M	PA30M	PA40M
SEHW 1204 AFSN	•				
SEHW 1204 AFTN		•			

SEHT 1204



I.C.	s	d ₁	b
12,7	4,76	5,5	2,1



ART.	K10M	PC30M	PC40M	PA30M	PA40M
SEHT 1204 AFEN					•
SEHT 1204 AFFN					•
SEHT 1204 AFFN-P	•				

Material	HBr.	APKT 11T3 APKT 1604 P - type K10M fz 0,1~0,2	APKT11T3 APKT1604 WV - type PC30M/PA30M fz 0,1~0,2	APKT11T3 APKT1604 WF - type PC40M/PA30M fz 0,1~0,2	SEHT1204 SEHW 1204 K10M fz 0,1~0,2	SEHW1204 PC30M fz 0,1~0,2	SEHT1204 PA40M fz 0,1~0,2
Carbon Steels	150		200 ~ 350	160 ~ 280		200 ~ 350	160 ~ 280
	190		140 ~ 250	110 ~ 200		140 ~ 250	110 ~ 200
	250		100 ~ 200	80 ~ 160		100 ~ 200	80 ~ 160
Alloyed- and Tool Steels	~200		180 ~ 300	140 ~ 240		180 ~ 300	140 ~ 240
	200 ~ 250		150 ~ 250	120 ~ 200		150 ~ 250	120 ~ 200
	250 ~ 325		140 ~ 200	120 ~ 160		140 ~ 200	120 ~ 160
	325 ~ 375		120 ~ 180	110 ~ 150		120 ~ 180	110 ~ 150
	375 ~ 425		100 ~ 150	80 ~ 120		100 ~ 150	80 ~ 120
	425 ~ 475		80 ~ 120	60 ~ 90		80 ~ 120	60 ~ 90
Stainless Steels	<i>Ferritic</i> 135 ~ 175		230 ~ 300	180 ~ 240		230 ~ 300	180 ~ 240
	175 ~ 225		180 ~ 240	140 ~ 190		180 ~ 240	140 ~ 190
	<i>Austenitic</i> 130 ~ 175		150 ~ 200	120 ~ 160		150 ~ 200	120 ~ 160
	<i>Martensitic</i> 275 ~ 325		130 ~ 180	100 ~ 140		130 ~ 180	100 ~ 140
	325 ~ 425		60 ~ 90	50 ~ 80		60 ~ 90	50 ~ 80
Cast Iron	<i>Carbon</i> ~ 150	140 ~ 220	180 ~ 350	140 ~ 280	140 ~ 220	180 ~ 350	140 ~ 280
	150 ~ 200	120 ~ 180	150 ~ 320	120 ~ 250	120 ~ 180	150 ~ 320	120 ~ 250
	<i>Alloyed</i> 200 ~ 250	90 ~ 140	120 ~ 260	100 ~ 200	90 ~ 140	120 ~ 260	100 ~ 200
	250 ~ 300	80 ~ 120	100 ~ 200	80 ~ 160	80 ~ 120	100 ~ 200	80 ~ 160
Cast Steel	<i>Carbon</i> ~ 150		180 ~ 240	140 ~ 190		180 ~ 240	140 ~ 190
	150 ~ 200		150 ~ 200	120 ~ 160		150 ~ 200	120 ~ 160
	<i>Alloyed</i> 200 ~ 250		120 ~ 180	100 ~ 140		120 ~ 180	100 ~ 140
	250 ~ 300		100 ~ 160	80 ~ 130		100 ~ 160	80 ~ 130
Aluminium	200 ~ 1000			200 ~ 1000			

